

ABSTRACT

A porcelain enamel composition having a metallic appearance is disclosed. The composition comprises about 45% to about 55% SiO₂, about 4 to about 20% R₂O, about 9 to about 15% B₂O₃, about 4 to about 12% MnO₂, about 1.5 to about 7% F₂, about 0% to about 20% MO₂, about 0% to about 10% RO, about 0% to about 6% NO₂, about 0% to about 2% P₂O₅, about 0% to about 3% CoO, about 0% to about 3% NiO, about 0% to about 3% Al₂O₃, about 0% to about 3% Fe₂O₃, about 0% to about 3% CuO, about 0% to about 4% ZrO₂, about 0% to about 2% Nb₂O₅, and about 0% to about 5% Sb₂O₃, wherein R₂O represents at least one alkali oxide, wherein RO represents at least one alkaline earth oxide and wherein MO₂ represents at least one opacifying pigment selected from the group consisting of ZrO₂, TiO₂, CeO₂, SnO₂ and La₂O₃.